

Work Order ID 47001B ✓

June 29, 2009 12:47:56 PM



Page 1

Item ID: D3186-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, LH

Start Date: 17/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

mf

Date:

09-09-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3186

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

ET 09-07-29

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8 09/08/04

(42) 8

120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP 50584

9/8/5

DS

Work Order ID 47001B

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Page 2

Item ID: D3186-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, LH

Start Date: 17/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 09-08-06
080812

1 of 1

Picklist Print

June 29, 2009 12:47:55 PM

Page 1

Work Order ID: 47001B



Parent Item: D3186-3RevD



Parent Item Name: Spacepod Door, LH

Start Date: 17/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D3186-1MRevD

Manufactured

No

Each

0.0000

1.0000



SPACEPOD DOOR LH

347001B01

mf 09-08-06

D350600-241

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 10:27:01 AM
User: Julie Dawson

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SPACEPOD DOOR LH |
| Job Number : 47001B | |
| Estimate Number : 12635 | |
| P.O. Number : | Part Number : D31863 |
| This Issue : 07/04/2009 S.O. No. : | Drawing Number : D3186 REV.D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : D |
| Previous Run : 45711B | Material : |
| Written By : | Due Date : 10/05/2009 Qty: 1 Um: Each |
| Checked & Approved By : JUD 09.04.07 | |
| Comment : Est Rev:A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------|------------------|
| 1.0 | 47001B01 | SPACEPOD DOOR LH |
|-----|----------|------------------|



/

Comment: Sub-Component SPACEPOD DOOR LH
1 x D3186-1M Batch _____

| | | |
|-----|-------------|-------------------------------|
| 2.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



/

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



/

Comment: INSPECT WORK TO CURRENT STEP

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



/

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

| | | |
|-----|------|------------------------------|
| 5.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



/

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



/

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



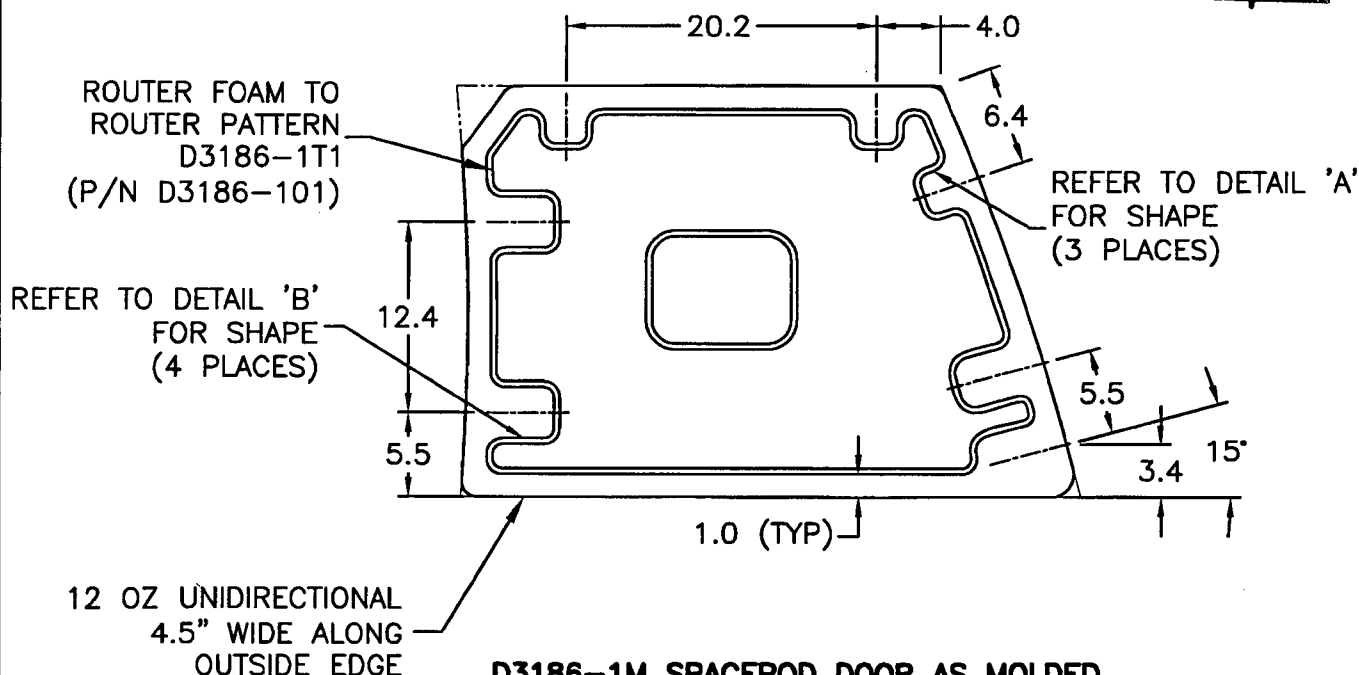
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| DESIGN DS | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED B | APPROVED H | DRAWING NO. D3186 | REV. D SHEET 1 OF 5 |
| DATE 07.02.22 | TITLE SPACEPOD DOOR | | SCALE NTS |
| A | 03.03.27 | NEW ISSUE | |
| B | 06.09.25 | DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED | |
| C | 06.12.13 | REMOVED D0600-XXX LABELS | |
| D | 07.02.22 | UPDATE DIMENSIONS | |

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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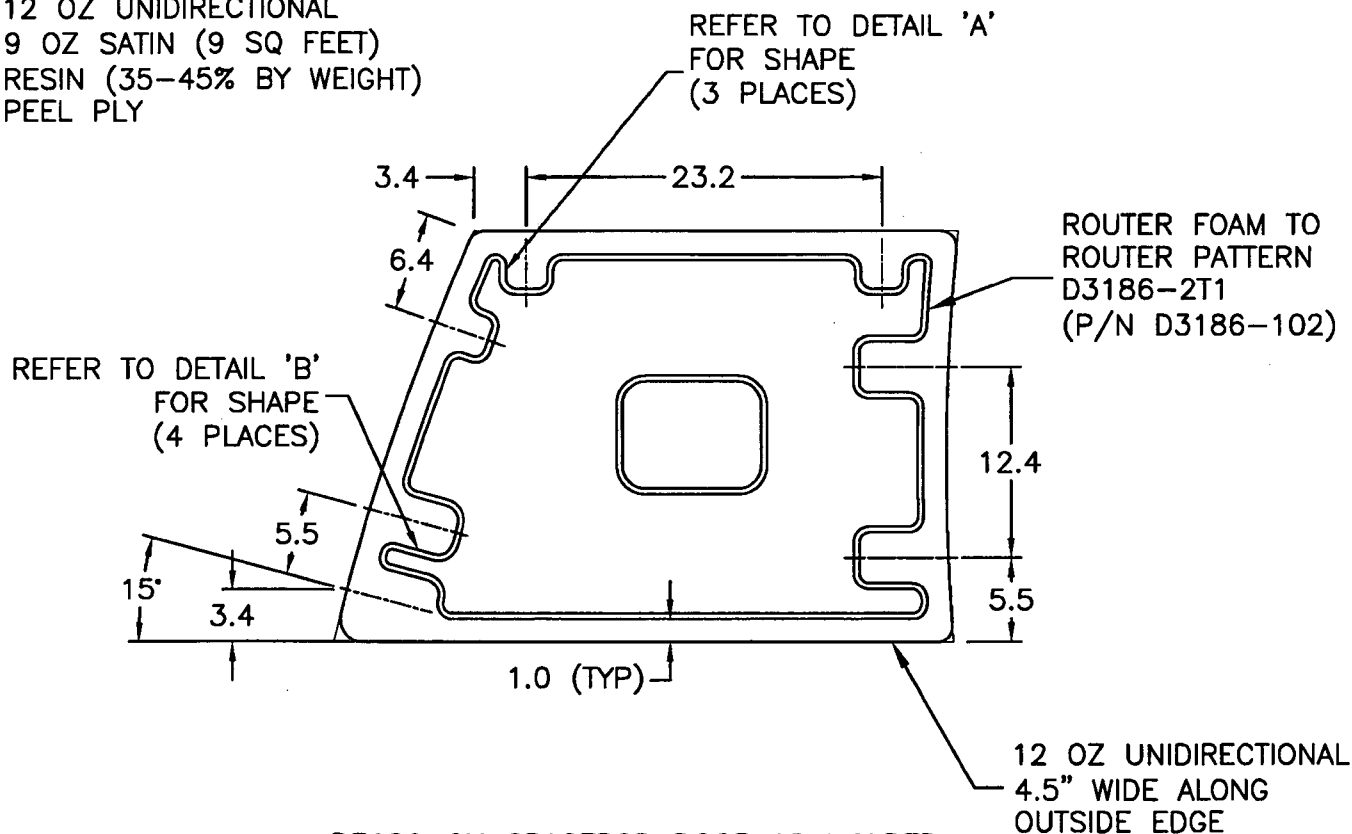
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| CHECKED B | APPROVED H | DRAWING NO. D3186 | REV. D SHEET 2 OF 5 |
| DATE 07.02.22 | TITLE SPACEPOD DOOR | | SCALE NTS |

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27



D31P6-2M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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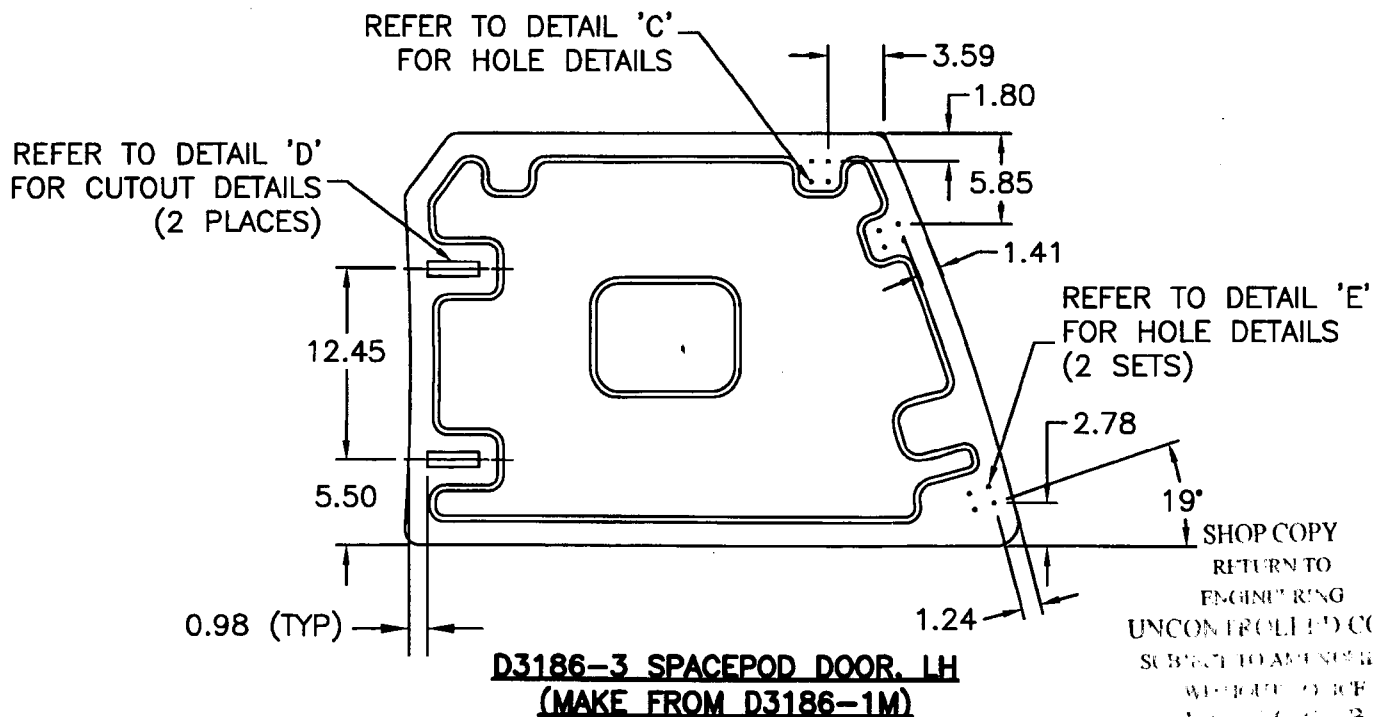
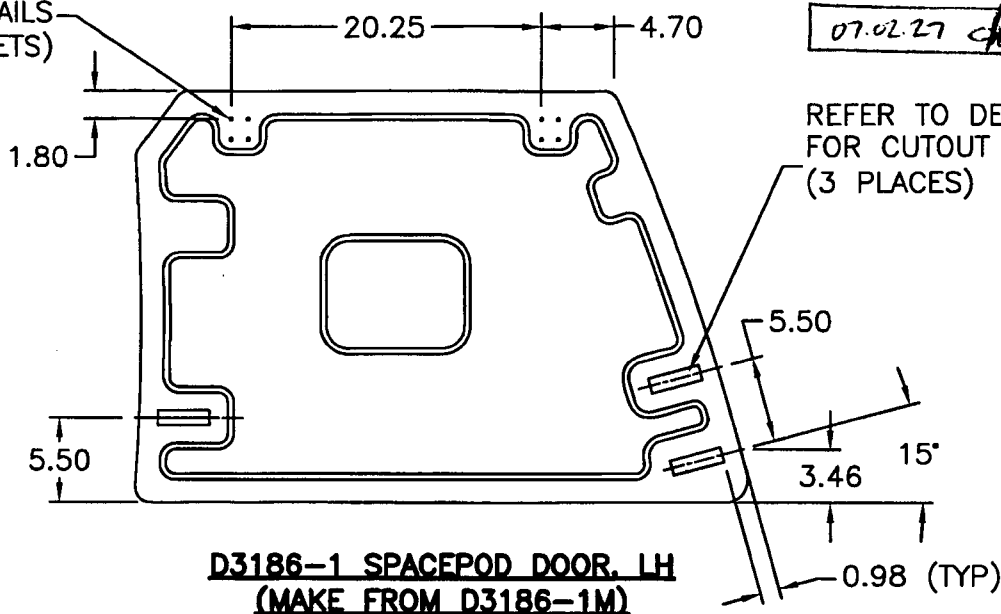
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| DATE 07.02.22 | TITLE SPACEPOD DOOR | | SCALE NTS |

REFER TO DETAIL 'C'
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(2 SETS)



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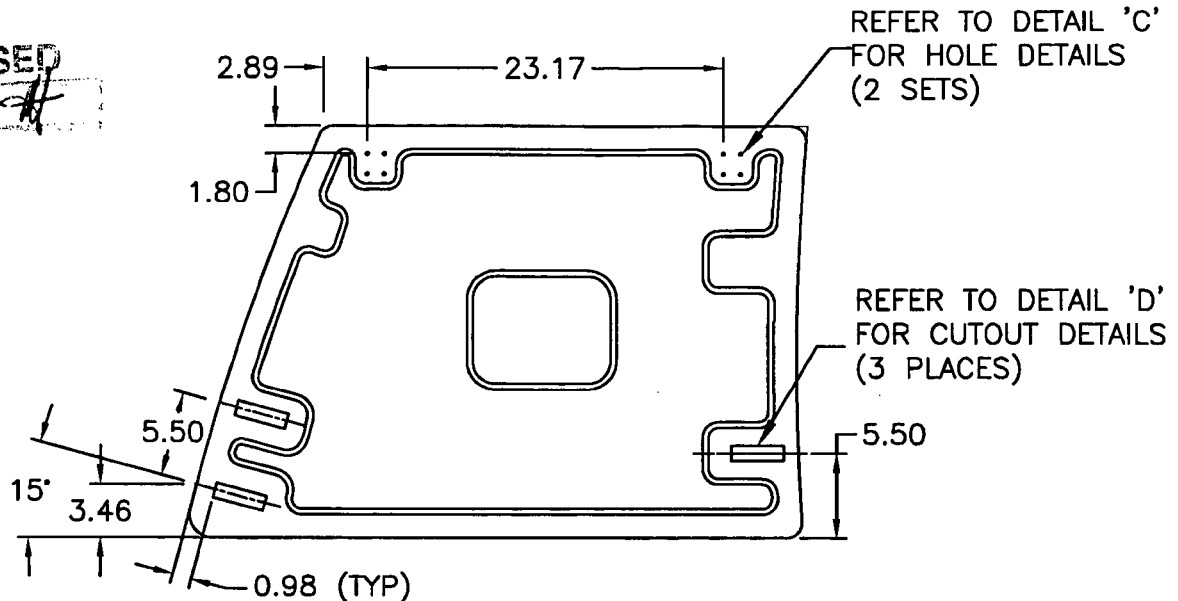
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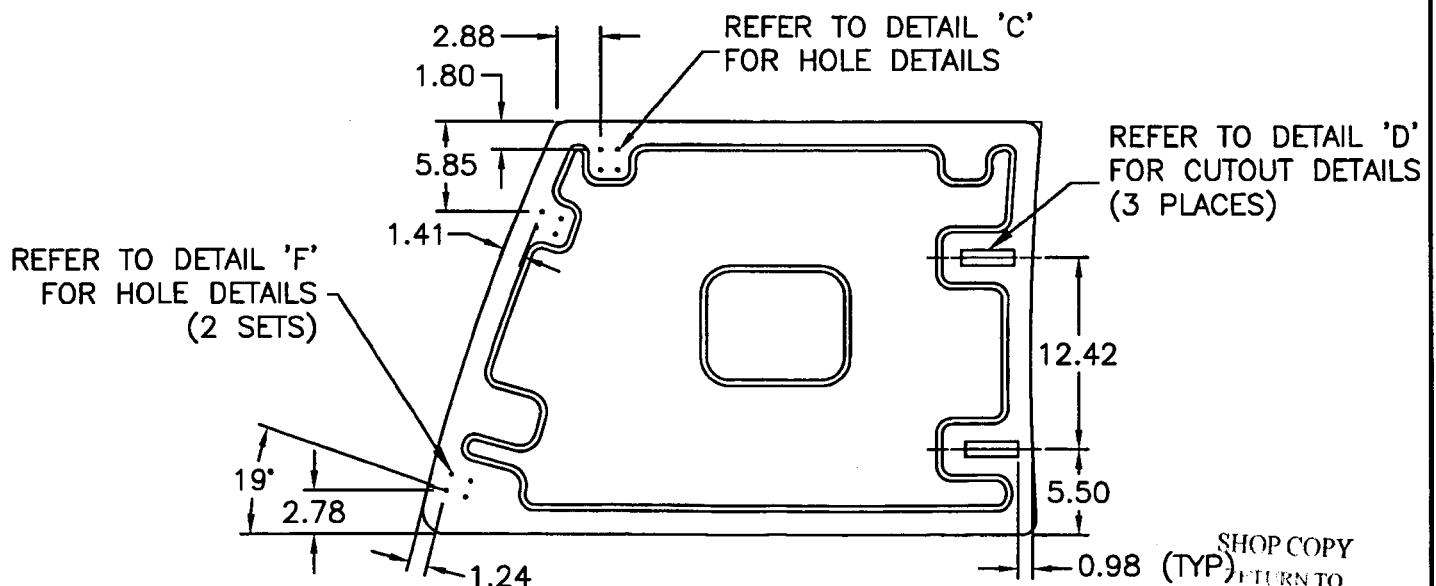
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| DATE 07.02.22 | TITLE SPACEPOD DOOR | | SCALE NTS |

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

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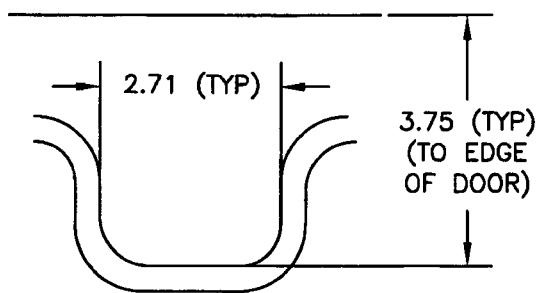
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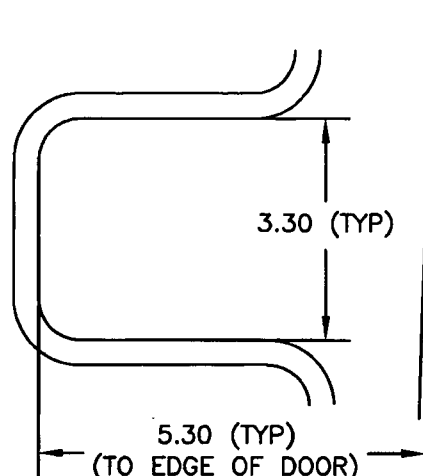
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| DATE 07.02.22 | TITLE SPACEPOD DOOR | | SCALE NTS |



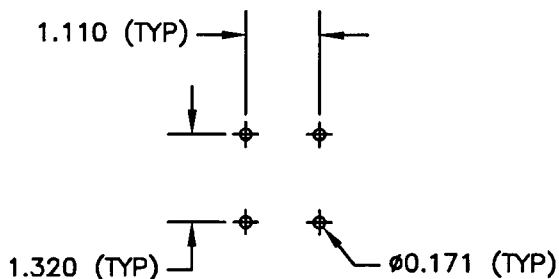
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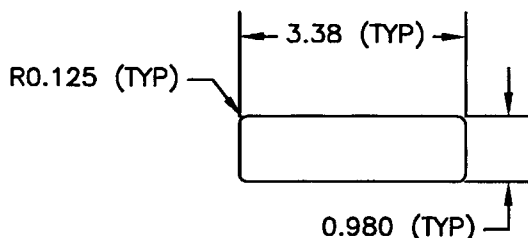
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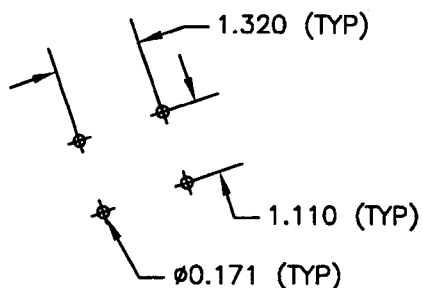


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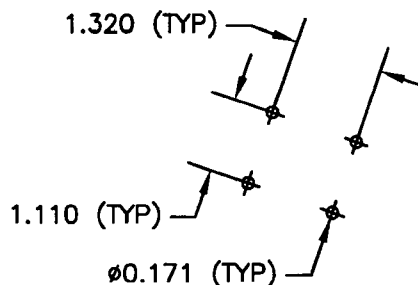


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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